

Work Order ID 53159

October 23, 2009 10:58:56 AM



Page 1

Item ID: D3983-9

Accept



Setup Start



Revision ID: A

Stop



Item Name: Spacer

20.0

Start Date: 23/10/2009 Start Qty: 10.00

Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00

Customer:



Reference:

Run Start



Approvals:

Process Plan: PL

Date: 07/10/23

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3983

A

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

1- Turn as per folio FA859 dwg D3983

2- Deburr

0.00

SA 09/10/26

20 ✓

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

SA 09/10/26

20 ✓

120

QC8- Inspect parts - second check

0.00



QC

Quality Control

Memo

0.00

SA 09/10/26

20 ✓

Work Order ID 53159

October 23, 2009 10:58:56 AM



Page 2

Item ID: D3983-9

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Setup Start



Revision ID: A

Stop



Item Name: Spacer

Start Date: 23/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

JS 09/10/26

(420) 0

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

m-h 09/10/26

(20X)

Quality Control

150

Identify as per dwg & Stock Location: 135

0.00



Packaging

Memo

0.00

09/10/27 (20)

Packaging

Work Order ID 53159

Page 3

October 23, 2009 10:58:56 AM

Item ID: D3983-9

Accept



Setup Start



Revision ID: A

Stop



Item Name: Spacer

Start Date: 23/10/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 30/10/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09-10-28
MK
09-10-27

Picklist Print

Page 1

October 23, 2009 11:15:22 AM

Work Order ID: 53159



Parent Item: D3983-9



Parent Item Name: Spacer

Start Date: 23/10/2009

Required Date: 30/10/2009

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R0.625 		Purchased	No			100	f	108.3857	0.4653			
6061 T6 Round Bar .625"												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

109733
110250
111450
112611
112697

108.3857
5.72
11.79
14.6157
16.26
60



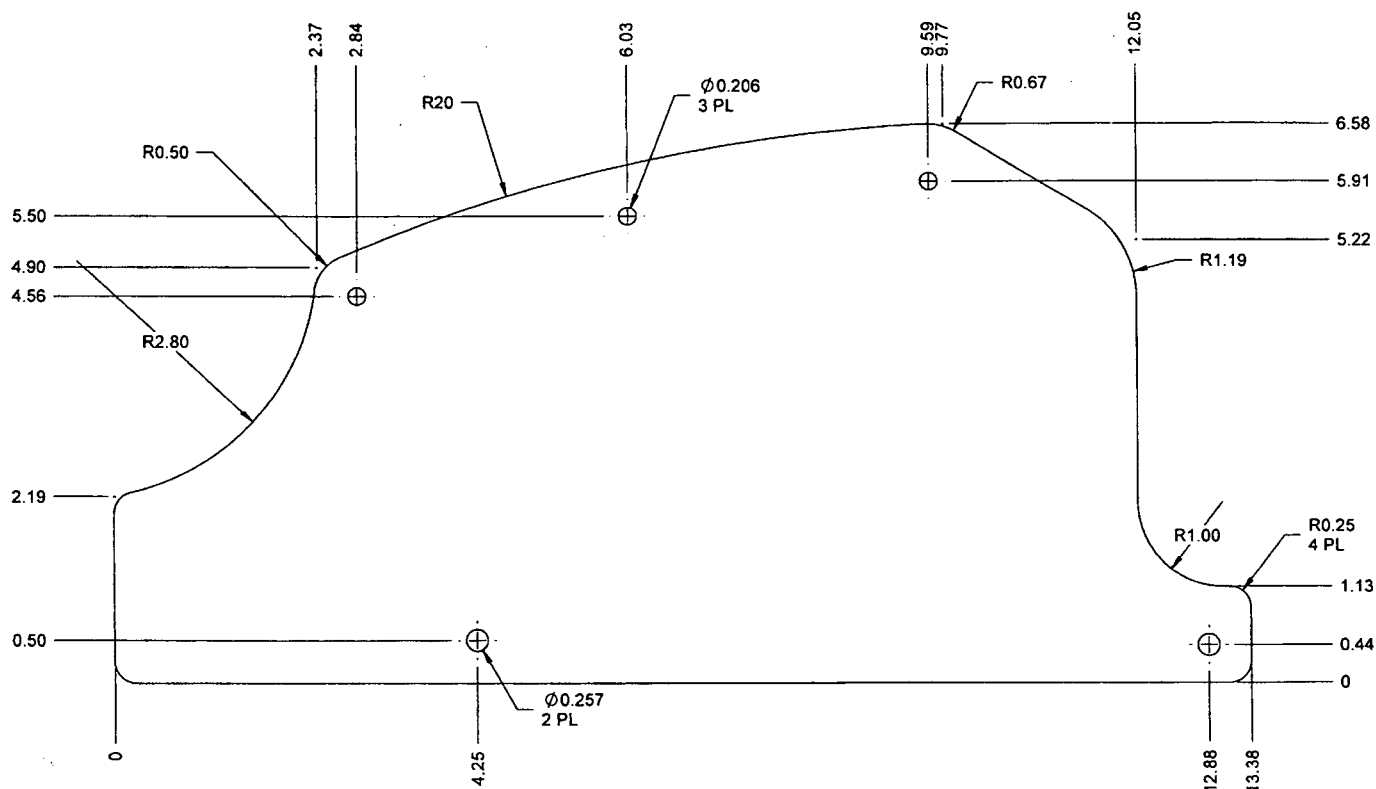
6061T6 R13 .500

B 111448

1.08 At

m6061T6R0.500

SA 09/10/26



D3983-1 OUTER CLOSEOUT

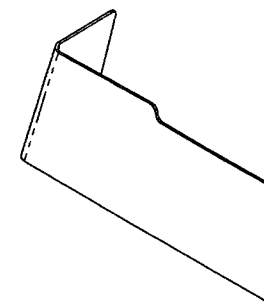
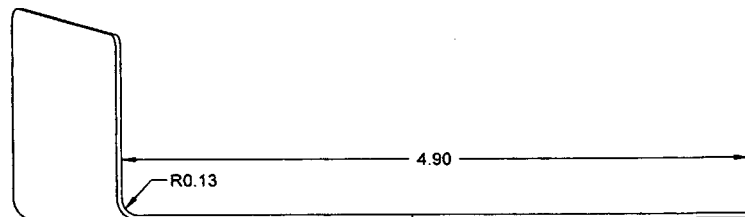
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53159
B10910-23

RELEASED
2009-10-13
W

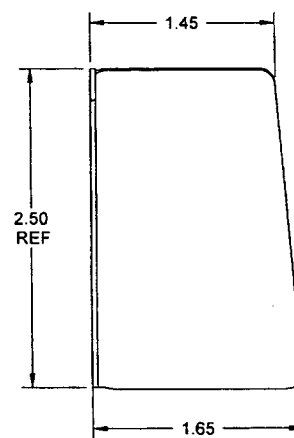
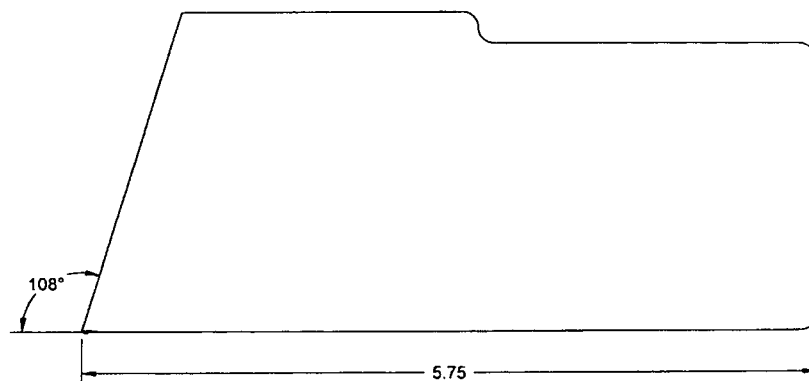
NOTES:
MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-1" AND B/N USING FINE POINT PERMANENT INK MARKER
WEIGHT: 0.26 lbs

A	NEW ISSUE	BY	09.09.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.09.09		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D3983**
REV. A
SHEET 1 OF 7
TITLE **CLOSE OUT KIT**
SCALE **NTS**
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u/o 53159

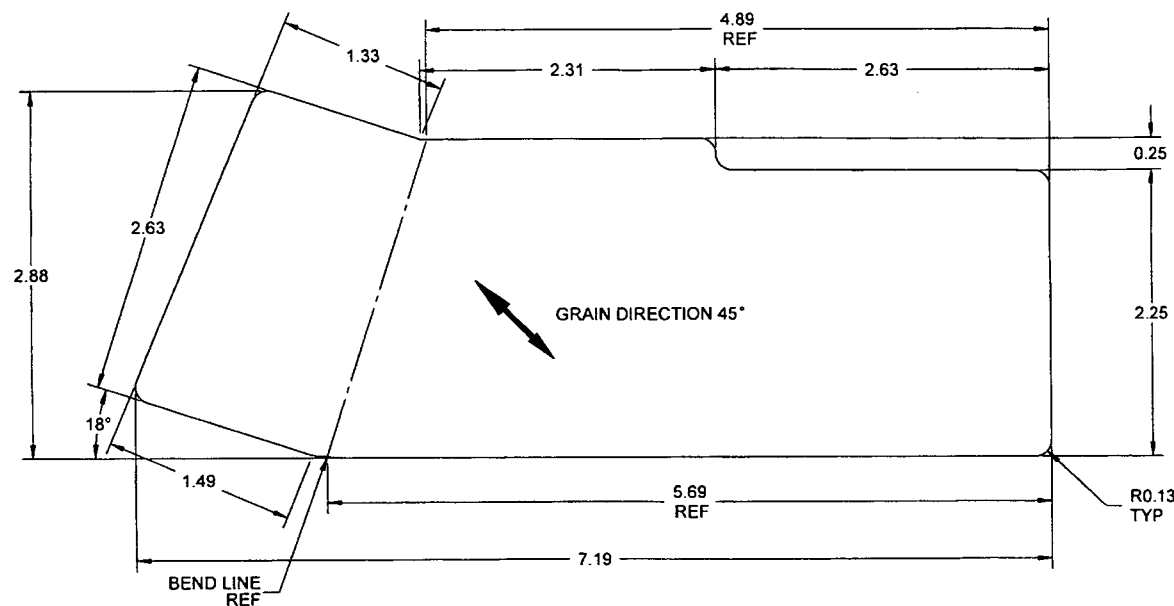


D3983-5 HINGE CLOSEOUT
(MADE FROM D3983-5F)

RELEASED
2009-10-13

NOTES:
MATERIAL: D3983-5F
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-5" AND B/N USING FINE POINT PERMANENT INK MARKER
WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3983	REV. A
MFG. APPR.		SHEET 3 OF 7	
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W/0 58159

D3983-5F HINGE CLOSEOUT FLAT PATTERN

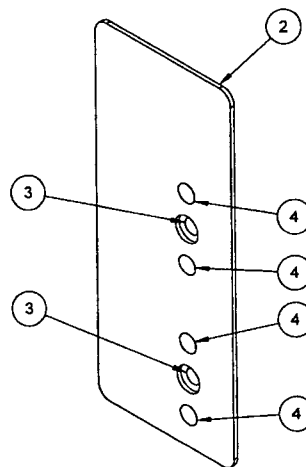
RELEASED
2009-10-13
MP

NOTES:
MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.040

FINISH: N/A
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: N/A
WEIGHT: 0.06 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
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MFG. APPR.		D3983	SHEET 4 OF 7
APPROVED		TITLE	SCALE
DE APPR.		CLOSE OUT KIT	NTS
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ITEM	QTY. -047	PART NUMBER	DESCRIPTION
1	X	D3983-047	CLOSEOUT ATTACHMENT
2	1	D3983-7	PLATE
3	2	MS21059L3	ANCHOR NUT
4	4	MS20426AD3-4	RIVET

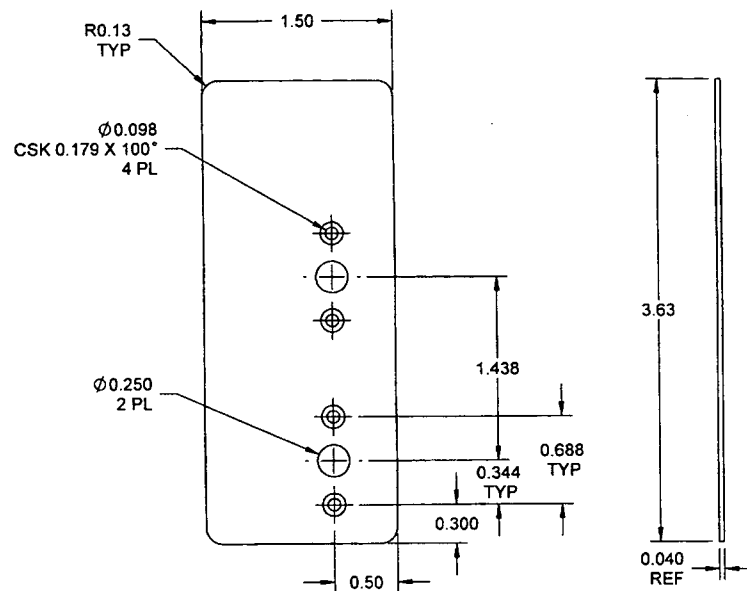


D3983-047 CLOSEOUT ATTACHMENT

RELEASED
2009-10-13
MD

NOTES:
 MATERIAL: SEE BOM
 FINISH: N/A
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 UNITS: INCHES UNLESS OTHERWISE NOTED
 BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-047" AND B/N USING FINE POINT PERMANENT INK MARKER
 WEIGHT: 0.03 lbs

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 5 OF 7
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D3983-7 PLATE

w/o 53159

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2009-10-13
MD

NOTES:
 MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
 REF DART SPEC M6061T6S.040
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 UNITS: INCHES UNLESS OTHERWISE NOTED
 BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 IDENTIFICATION: N/A
 WEIGHT: 0.02 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3983	SHEET 6 OF 7
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	CLOSE OUT KIT	NTS
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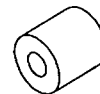
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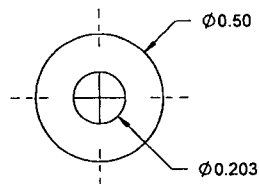
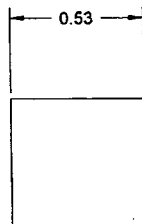
3

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w/ 53159

**D3983-9 SPACER**

RELEASED
2009-10-13

NOTES:

MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM ROUND BAR, Ø0.500
 PER AMS-QQ-A-225/8 (OR AMS 4117/4122/4128/4115/4116) OR
 PER AMS-QQ-A-200/8 (OR AMS 4160)
 REF DART SPEC M6061TR

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 UNITS: INCHES UNLESS OTHERWISE NOTED

BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 IDENTIFICATION: IDENTIFY WITH DART P/N "D3983-9" AND B/N USING FINE POINT PERMANENT INK MARKER
 WEIGHT: 0.01 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3983	SHEET 7 OF 7
APPROVED		TITLE	SCALE
DE APPR.		CLOSE OUT KIT	NTS
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